

Work Order ID 76786-1

November-21-11 11:11:38 AM

\*76786\*

Page 1

Item ID: D3805-045

Revision ID:

Item Name: Wearplate Assembly Aft. Low Gear

Start Date: 21/11/2011 Start Qty: 8.00

Required Date: 04/01/2012 Req'd Qty: 8.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: M.C.J

QC:

Date: 11/11/21 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3805

B

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

1-weld D3806-5 to D3805-5 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: m118367

2-Transfer drill holes in bar

2059B → m120165

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Quality Control

Memo

0.00

③ MAL/L2 12/01/17

Cpc 12-01-17 3X Ø

# Work Order ID 76786

November-21-11 11:11:39 AM

**\*76786\***

Page 2

Item ID: D3805-045  
 Revision ID:  
 Item Name: Wearplate Assembly Aft. Low Gear  
 Start Date: 21/11/2011 Start Qty: 8.00  
 Required Date: 04/01/2012 Req'd Qty: 8.00  
 Reference:

Accept

**\*N9000040100\***

Setup Start **\*NS1\***  
 Stop **\*NS2\***

Cust Item ID:  
 Customer:

**\*8\***  
**\*8\***

Approvals: Process Plan:  
 QC:

Date:  
 Date:

Tooling:  
 SPC (Y/N):

Date:  
 Date:

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/  
 Work Center ID

Operation  
 Description

Set Up/  
 Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120  
**\*120\***  
 QC  
 Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*5 12/6/17*

130  
**\*130\***  
 Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powder Coating

Memo

START TIME: *10:50*  
 OVEN TEMPERATURE: *320 OF*  
 FINISH TIME: *11:20*

0.00

*3 x 2 m 12/6/17*

140  
**\*140\***  
 QC  
 Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

*3 x 2 m 12/6/17*  
*counted & measured*

WORK ORDER CHANGES

W/O: 78786-1

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3805-045 PAR #: Fault Category: Sam Job NCR: Yes No DQA: Date: 12/1/23  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 12/1/23

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/17	150	Found 1 gasket D3807-5 add e defiant when put on water jet	S 12/01/17 12/01/23 PST042	Scrap & destroy 2741	S 12/01/17	S 12/01/17	S 12/01/17 12/01/23 PST042	S 12/01/17

NOTE: Date & initial all entries

November-21-11 11:11:42 AM

**Parent Item Name:** Wearplate Assembly Aft. Low Gear

\*D3805-045\*

Required Qty: 8.00

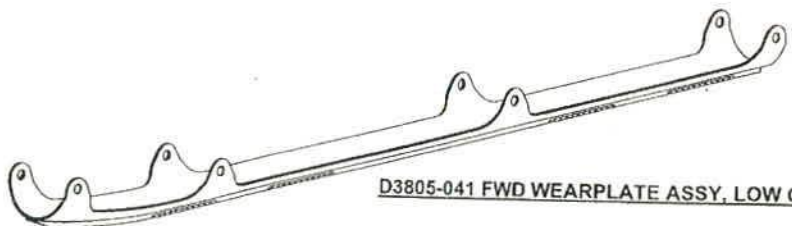
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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7674 =

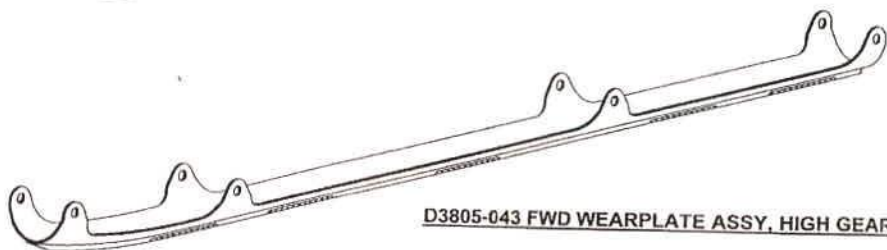
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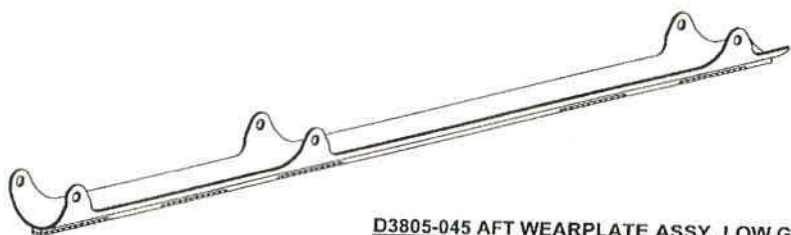
8 7 6 5 4



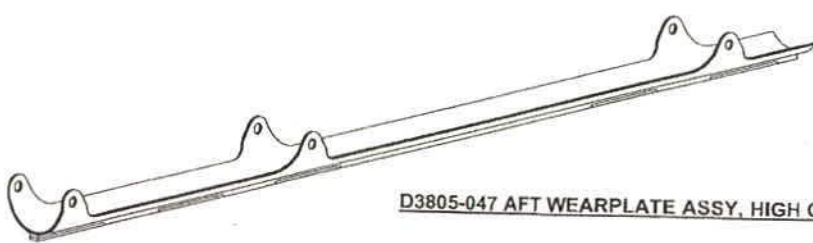
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

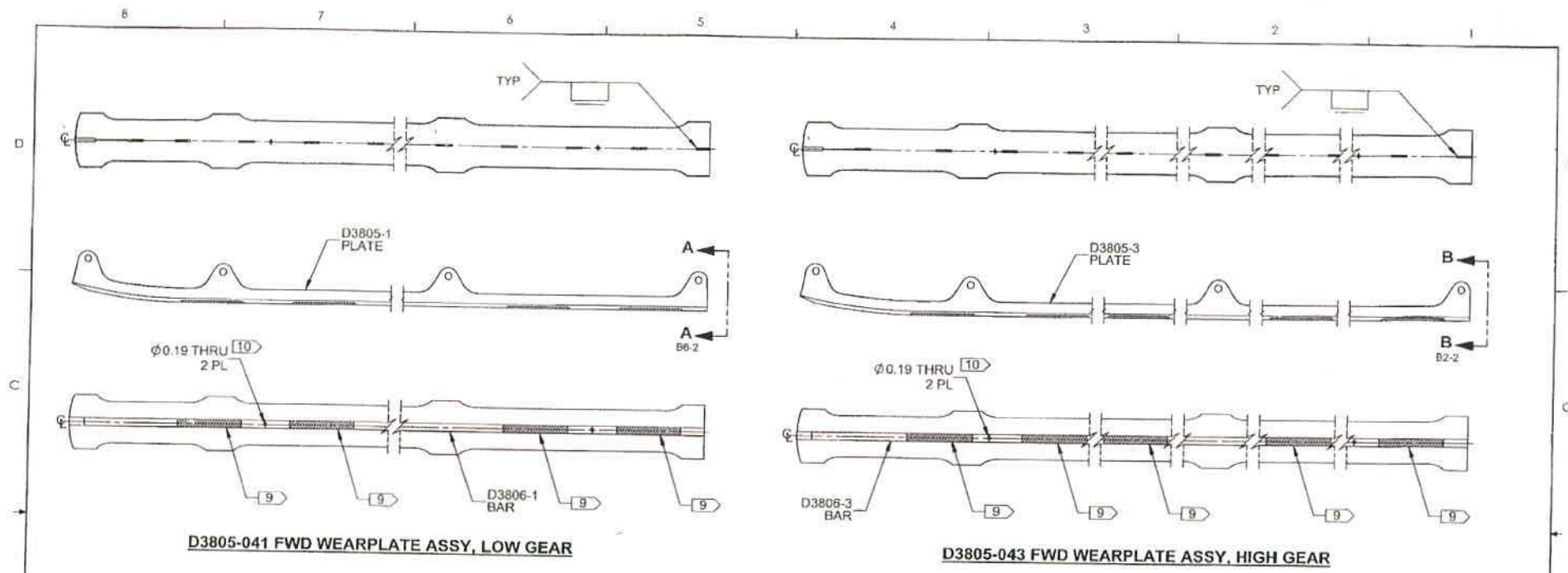
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

RELEASED  
2011-10-03

76786 HCS  
11/11/21

B	REVISED D3805-1F13F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT TWO END OF PLATE PER PAR11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MD	11.09.16
A	NEW ISSUE		MD	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWN		DART AEROSPACE USA, INC. KENT, WA	
CHECKED	MFG. APPR.		DRAWING NO.	REV. B
APPROVED	DE APPR.		D3805	SHEET 1 OF 8
DATE	11.09.16		TITLE	SCALE
			WEARPLATE ASSY	NTS
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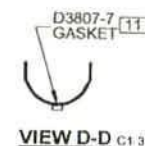
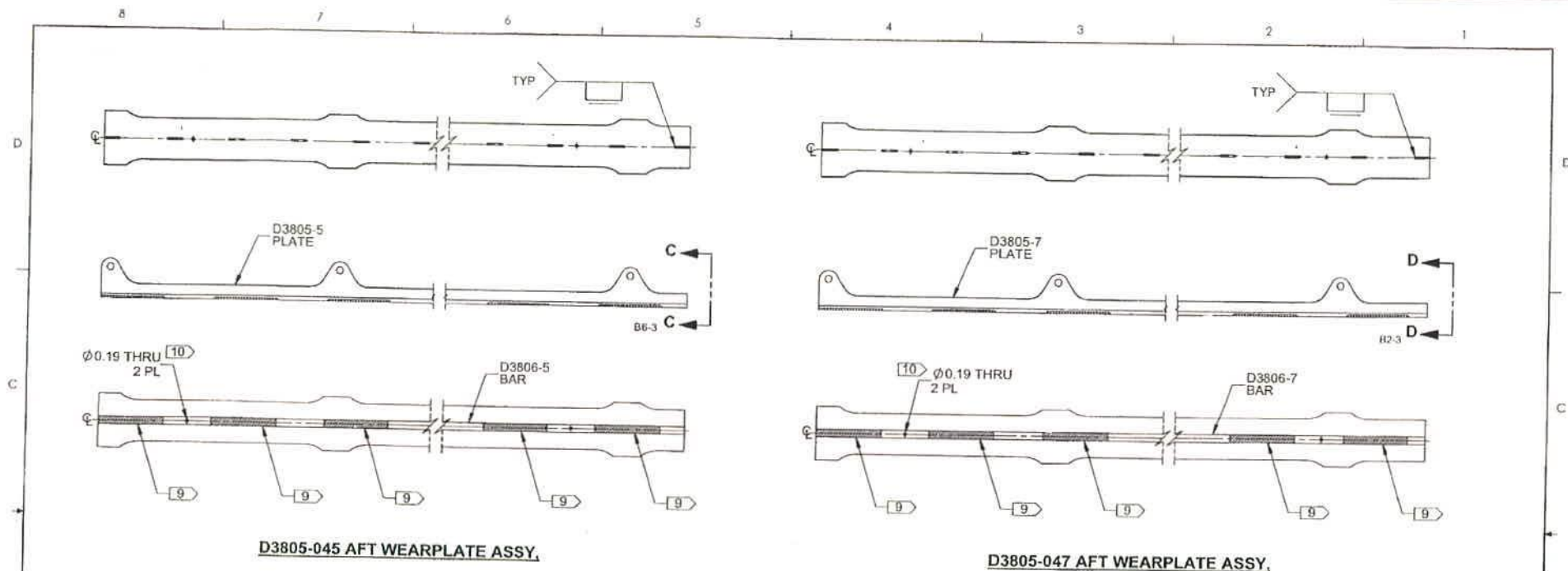


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2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.76 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
  - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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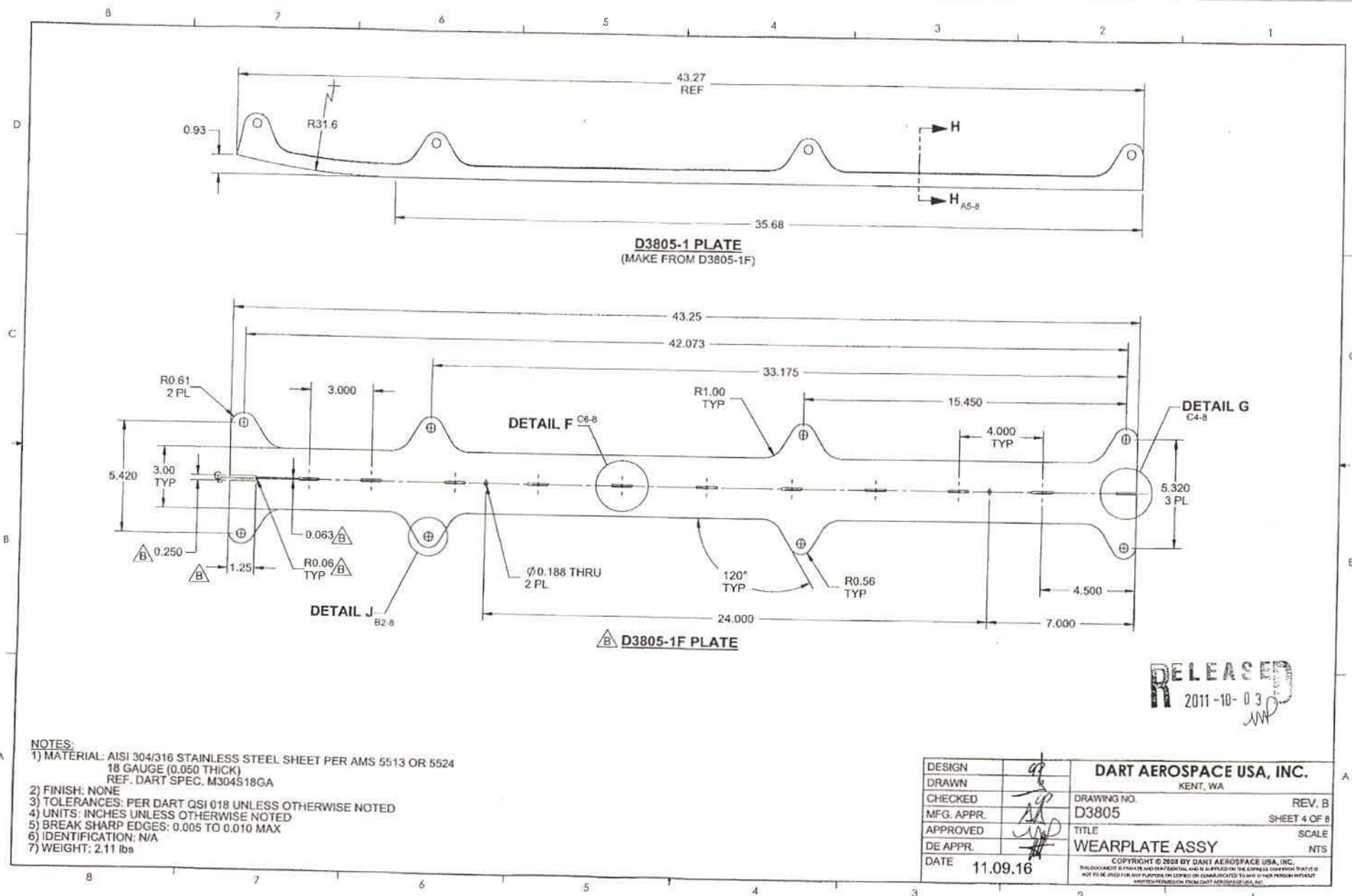


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- NOTES: **B**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
  - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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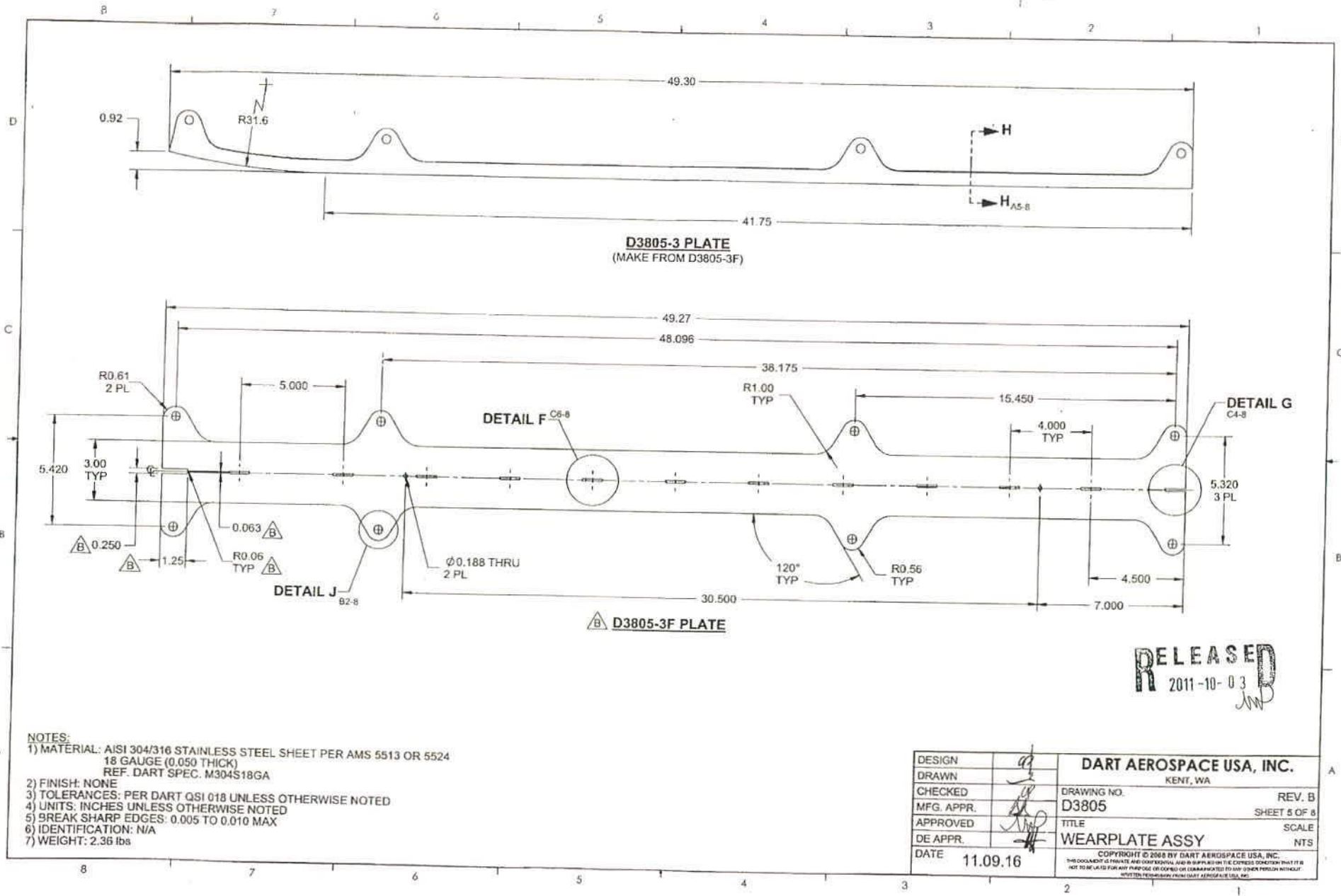
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2011-10-03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.11 lbs

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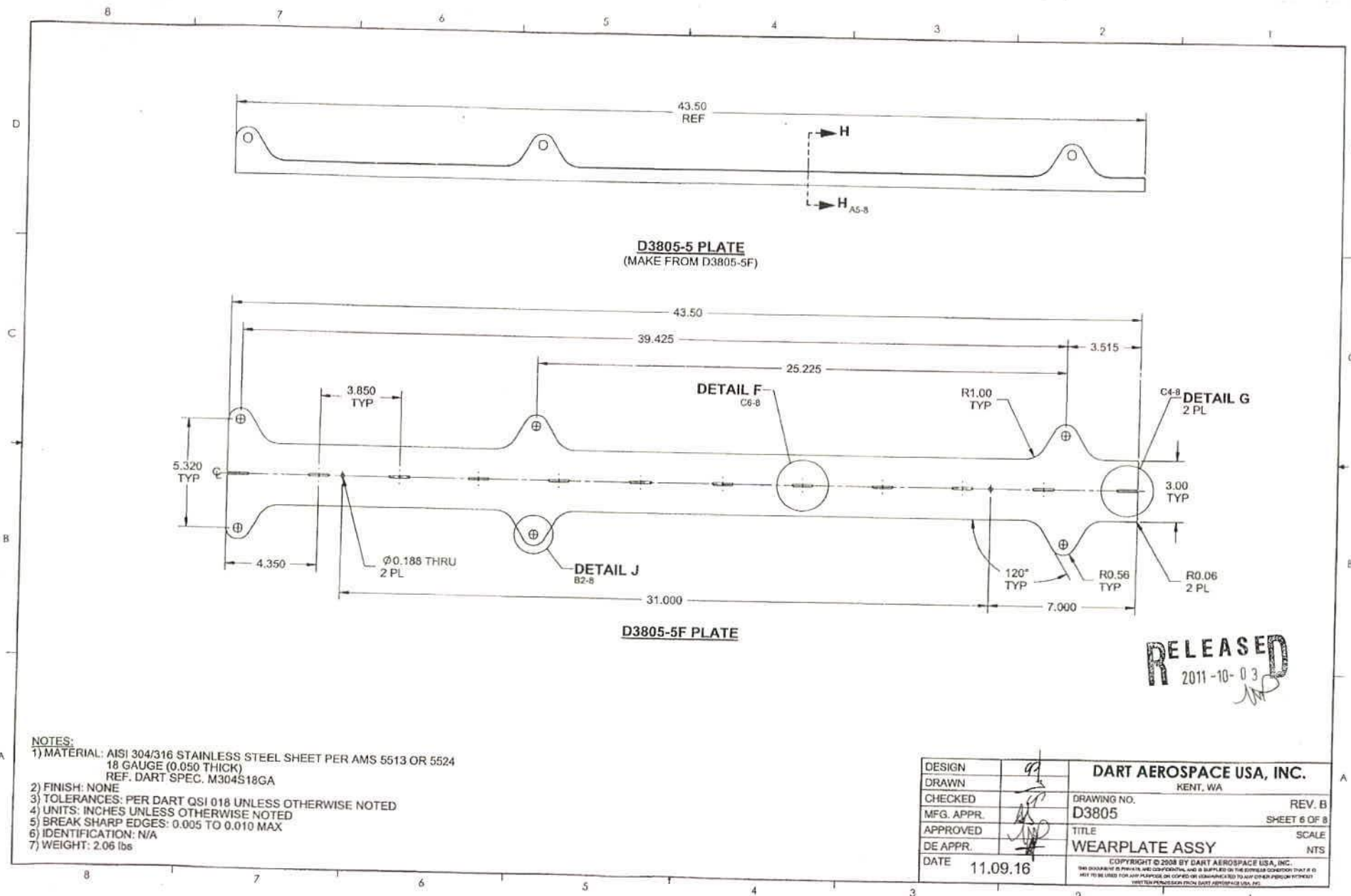


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  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.36 lbs

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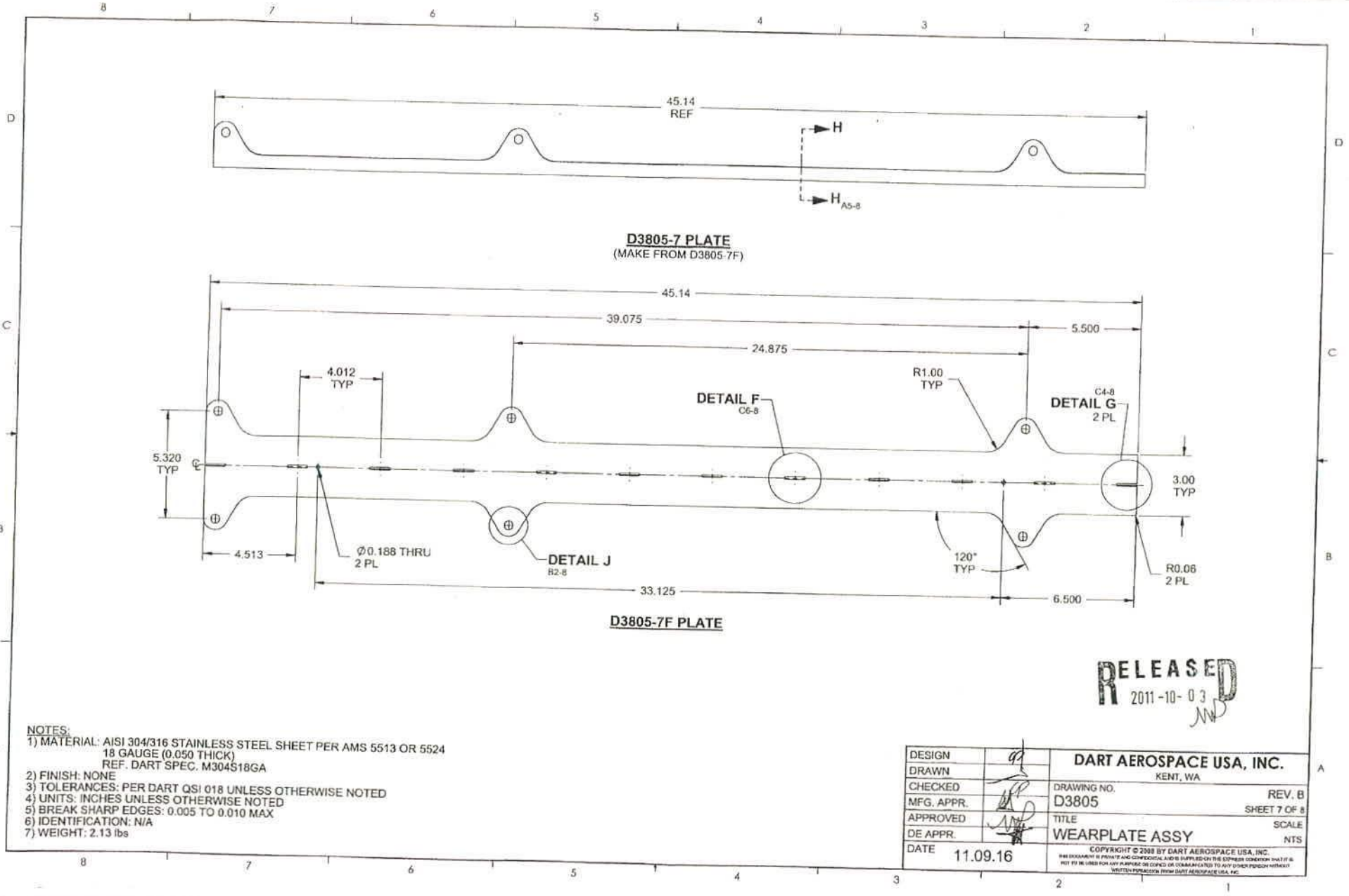


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18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.06 lbs

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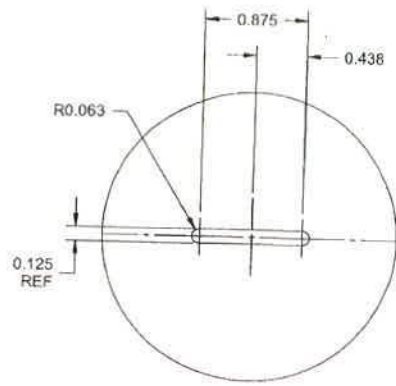


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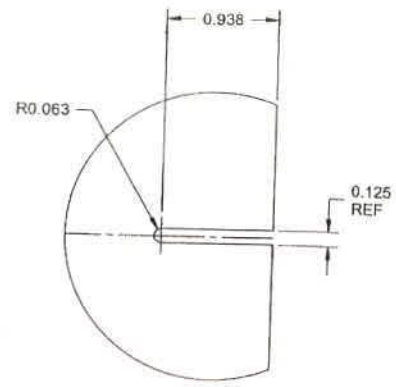
- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
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  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.13 lbs

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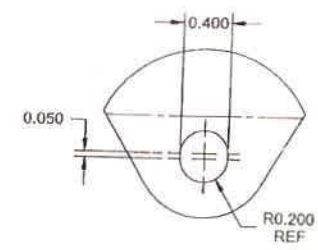
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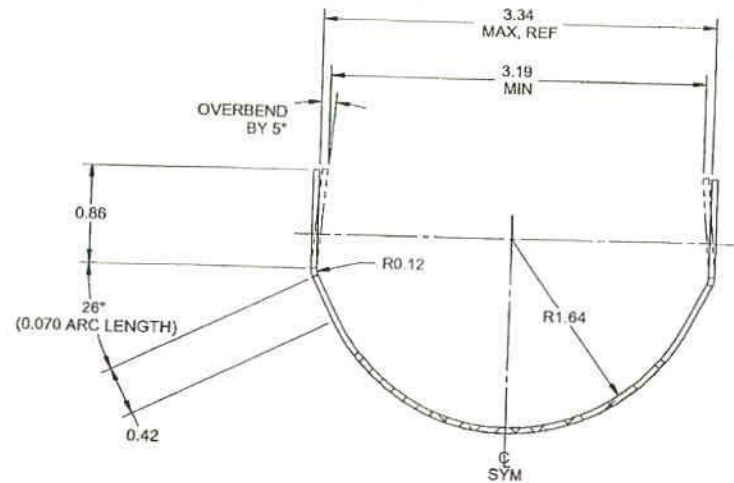
**DETAIL F**  
SLOT DETAIL TYP  
SCALE 4X  
C5-4  
C5-5  
C4-6  
C4-7



**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X  
C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X  
D6-4  
D7-5  
D5-6  
D5-7



**SECTION H-H**  
SCALE 4X  
D3-4  
D3-5  
D3-6  
D3-7

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2011-10-03  
JW

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